

Work Order ID 75282

October-20-11 8:13:17 AM

75282

Page 1

Item ID: D2580-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 205 Skidtube bent detail
 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 24/10/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.V Date: 11/10/20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D DEO-DT Rev E. E 11.10.20								

100 0.00

100

Skidtubes

Skidtubes

Memo

0.00

- 1- Inspect mat'l D2500-1-190 for damage.
- 2-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)
- 3-Open holes to 0.500" as per Dwg D2580 without cutting fluid
- 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube
- 5- Chemical Conversion Coat as per QSI 005 4.1
- 6-Bond web in place per QSI 015.

A/R Sikaflex-291 batch: 119399
 Sikaflex expire date: 2012-08-13
 Start time and date: 3:47:21 bond for 12hrs

5h30

24 11/10/26
 SAD 11-11-06 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Item Name: 205 Skidtube bent detail
Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 24/10/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
101 *101* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00			11-11-7				
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00			11-11-7				
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>4/6</u> Memo	0.00 0.00			11-11-7				

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 20/10/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 24/10/2011 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

11-11-07
(2)

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Picklist Print

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Page 1

Work Order ID: 75282

75282

Parent Item: D2580-1

D2580-1

Parent Item Name: 205 Skidtube bent detail

Start Date: 20/10/2011

Required Date: 24/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C
10.12.01 as per DEO D1 DD verf:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-1-190

Manufactured

No

100

Each

23.0000

1

2

D2500-1-190

Ext'n - I' Beam Tube 4"

**

Location

Loc Qty

Loc Code

LG

23

66296

23

D2596

Manufactured

No

100

Each

6.0000

1

2

D2596

Web, 205 Skidtube

**

Location

Loc Qty

Loc Code

LG046

6

74748

6

DP 11-11-9

SAD 11-11-06

2

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LIST OF MATERIALS					PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047			
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1		D2500-1-190	EXTRUSION
5			16		D2570	BUSHING
6	1	1	1		D2576-3	STEP
7	20	24	25		D2579	SPACER
8	16	16	8		D2594-1	PLUG
9	16	16	8		D2594-3	O-RING
10	1	1	1		D2596	205 WEB
11	1	1	1		D2855	AFT CAP
12	1	1			D3564-5	WEARSHOE
13	1	1			D3564-9	WEARSHOE
14	1	1			D3564-11	WEARSHOE
15	1	1			D3564-13	WEARSHOE
16	2	2			D3566-1	GASKET
17	1	1			D3566-5	GASKET
18	1	1			D3566-13	GASKET
19			1		D4406-041	WEARPLATE ASSEMBLY
20			1		D4406-043	WEARPLATE ASSEMBLY
21	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50			AN3C4A	BOLT
23	2	2	2		AN3-5A	BOLT
24			8		AN4-45A	BOLT
25	50	50			NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
27			8		MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2011-08-29

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 75282 M.C.J

11/10/20

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 1 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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NOTE: Date & initial all entries

8 7 6 5 4 3 2



C

B



11

Diagram illustrating the underside of the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH 4 PL
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576-3
- $\frac{1}{4}$

DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 2 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1 0

WHITE PINE NEWS/SPRING FRESH DART AIRPORT

Dart Aerospace Ltd

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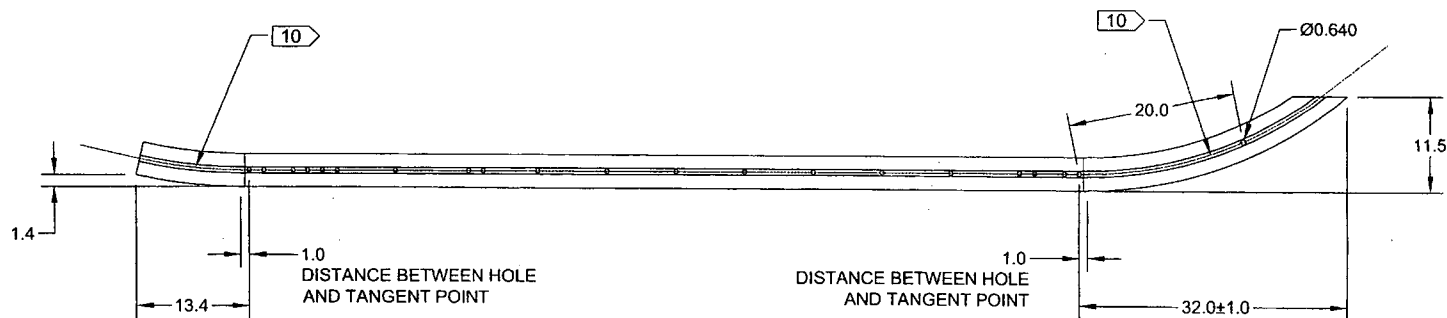
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75282



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2011-08-28

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	N	D2580	SHEET 3 OF 8
APPROVED	142	TITLE	SCALE
DE APPR.	#	205 SKIDTUBE ASSEMBLY	NTS
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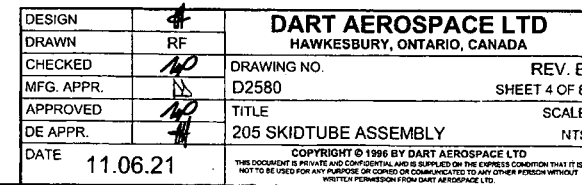
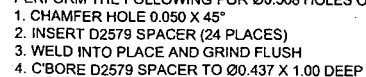
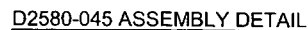
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RELEASE
2011-08-29
IN

DETAIL G D3-5
SCALE 5X

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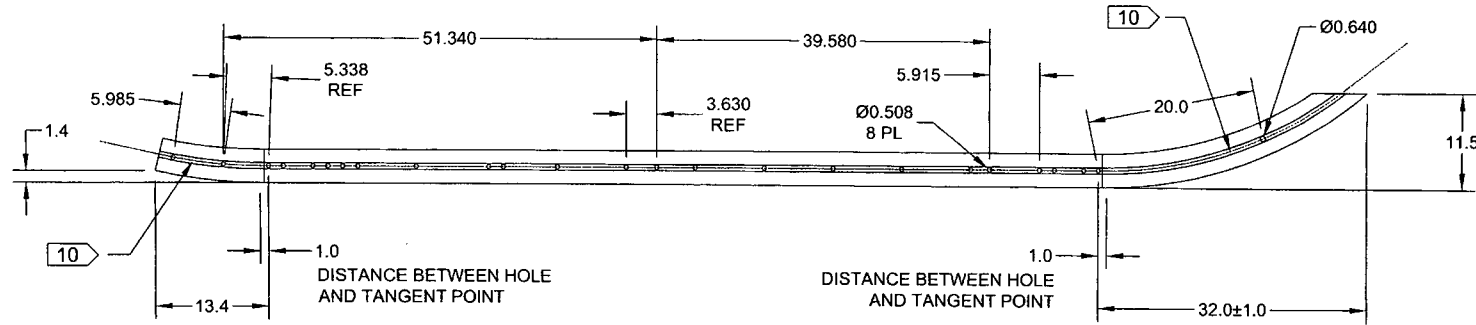
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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2011-08-29

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 5 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
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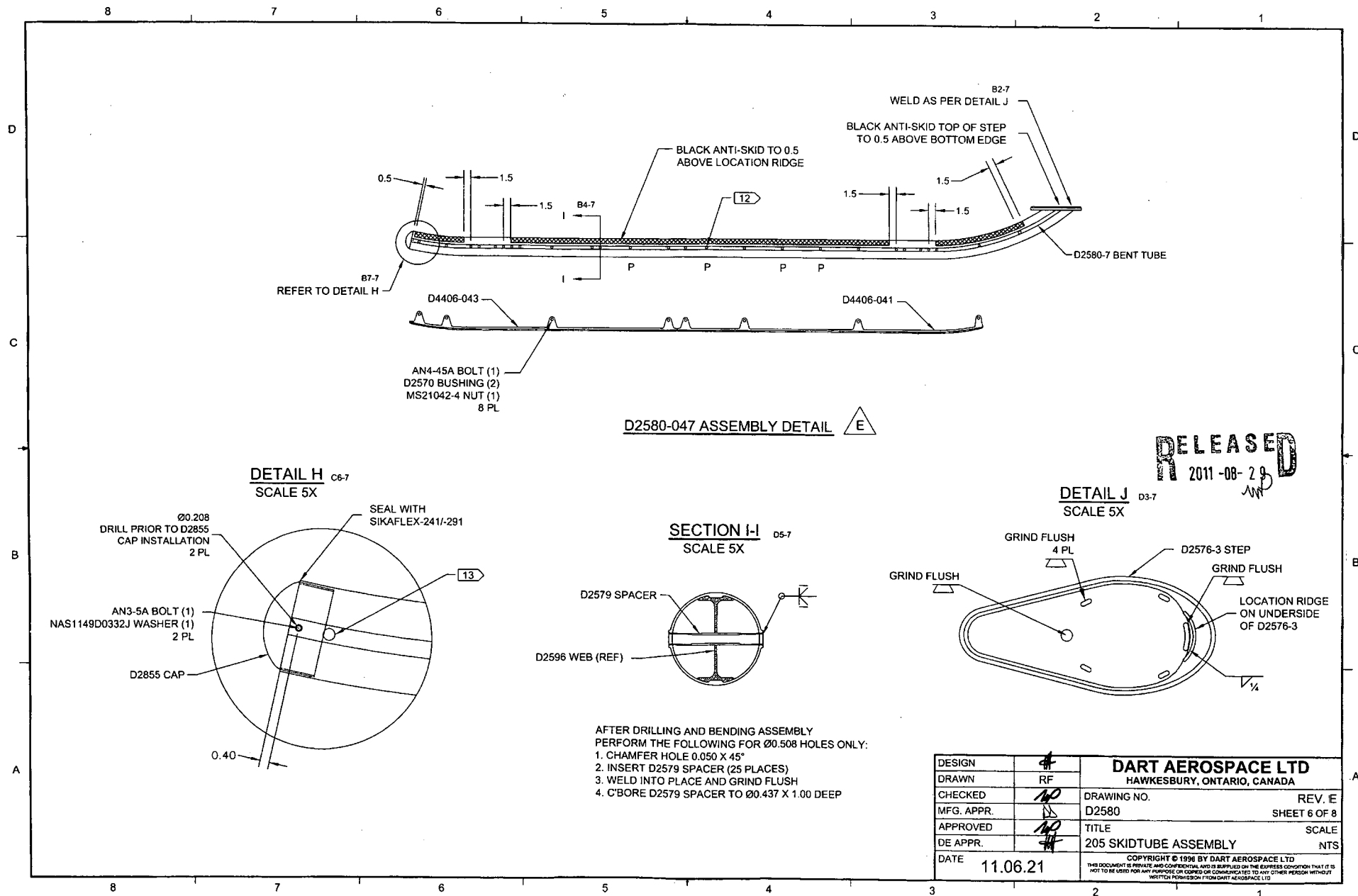
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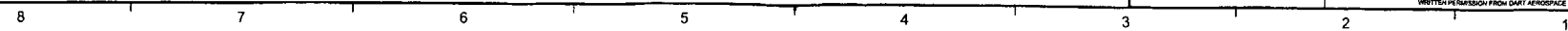
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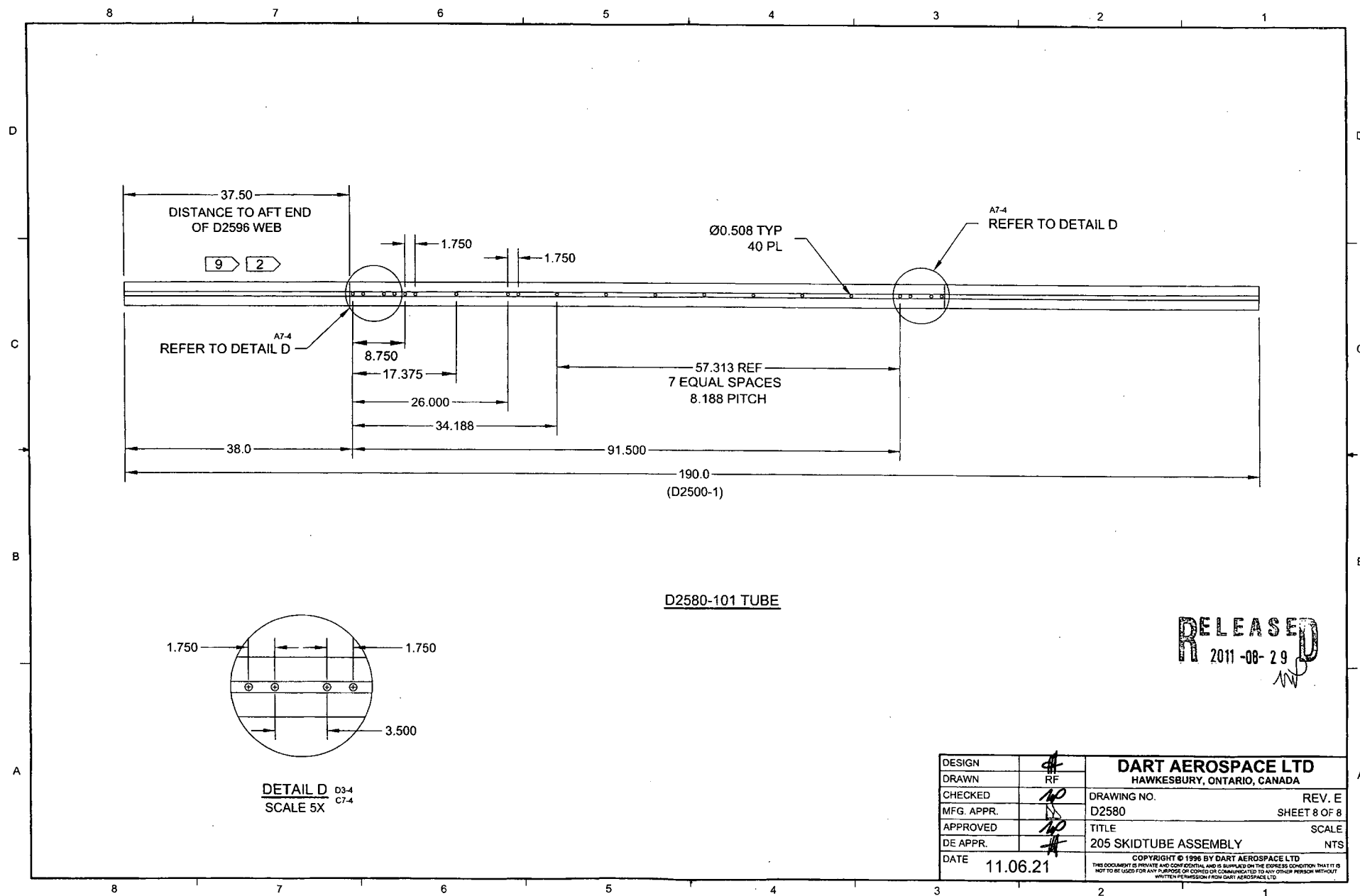
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